



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A93-3300-20

Job Sheet 197352



Part No: RBE350A93-3300-20

Job Qty: 14 pcs

Part Name: Tail Rotor Hub Socket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/4/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 9/2/19

Description:

Type: Stock

Note: DWG RBE350A93-3300-20 REV:3 IPP REV:A 18.01.15 NEW ISSUE RQ VERIFIED BY:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	SL-2500Y - 1	14 pcs	9/2/19	9/2/19	1.00	0.70	SL-2500Y - 1		19-11-3
110	QC 2	14 pcs	9/2/19	0.00	0.00		QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		12
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

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120 QC 8	14 pcs	9/2/19	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130 Outsource - 12 - Black Oxide	14 pcs	9/2/19		GRO002-VC	10
140 Packaging 2-1 - Receive - B4B	14 pcs	9/2/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	

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					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
145 QC 6	14 pcs	9/2/19	0.00 0.00		QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
150 Packaging 3-1 - Stock - B4B	14 pcs	9/2/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
160 QC 21 - FG	14 pcs	9/2/19	0.00 0.00		QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - SA - 53	

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Part Op 100 - SL2500Y (MORI SL2500Y LATHE) 1-Machine as per folio FB748 FOLIO REV: AA DWG REV: 3
 Descriptions: 2-Debur
 110 - (QC2- Inspect parts off machine FAI/FAIB) 1-Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.
 120 - (QC8- Inspect parts - second check)
 130 - Issue P/O to Groupe Altech; PO 45078 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required
 140 - (Receive & Inspect for Damage & Mat'l Certs)
 145 - (QC6- All purchased or subcontracted products)
 150 - (Identify as per dwg & Stock Location: _____)
 160 - (QC21- Final Inspection - Work Order Release)

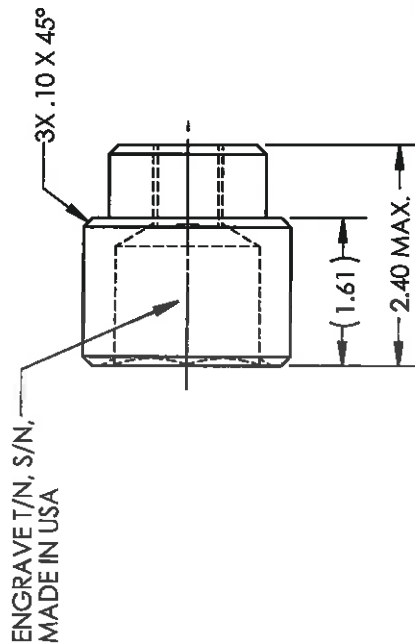
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
J07540M	Socket	14 Ea (1 ea)	100-SL-2500Y - 1	S198077 S172541
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-SL-2500Y - 1	J07540M	14	6	0
Part Specifications				
Specifications could not be found.				

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 197352 MVS 190705

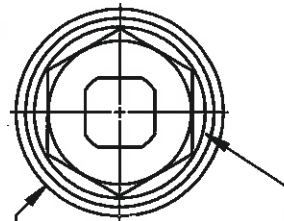
REV	ECK	DESCRIPTION	DATE	INITIAL	APPROVED
1		CHD DIM WAS Ø2.11 IS Ø2.10 - 2.08. ADDED MAKE SURE FACTORY MARKINGS ARE REMOVED AND MADE IN USA.	4/29/2009	RJC	
2		ADDED CHAMFERS AND CHD FROM A 1.9/16in. 1/2 in. DRIVE SOCKET TO A 40mm 3/4 in. DRIVE SOCKET PER HELICO PRODUCTS SPEC. ALSO CHD UPPER O.D. TOLERANCE WAS Ø2.11 IS 2.2 TO ACCOMMODATE 40mm SOCKET PER DW.	9/29/2009	WP	
2A		CHD T/N WAS RBEA93-3300-20 ISA RBE350A93-3300-20.	6/19/2013	BIM	RW
3	15-0147	CHD BUYOUT INFO WAS SNAP-ON IS PROTO. CHD OAL WAS (2.23) IS 2.40 MAX. CHD DIM WAS Ø2.10 - 2.08 IS (Ø2.25). ADDED NOTE 1, CORRECTED ORIGINAL NO. REF. WAS RBEA93-3302-02 IS RBEA93-3300-20.	6/24/2015	RJC	JAG



ENGRAVE T/N, S/N,
MADE IN USA

(Ø2.25)

MAKE SURE FACTORY
MARKINGS ARE REMOVED



SKIM FRONT FLUSH (.08)

ORIGINAL No. REF.
DO NOT USE FOR REF. ONLY
RBEA93-3300-20 = 350A93-3300-2.

NOTE:
1. PART OF AGUSTA KIT RBEA62309.

DART AEROSPACE		TITLE TAIL ROTOR HUB SOCKET	
DWG NO. RBE350A93-3300-20		REV 3	
MATERIAL STEEL		DRAWN BY PERRITT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED <i>D. Wood</i>	
XXX ± .005		FINISH BLACK OXIDE	
XX ± .01		SPEC	
X ± .1		ANGLES ± .5°	
1. BREAK ALL SHARP EDGES .015 x 45°		USED ON MODEL AS350A	
OR .015R		DATE 3/19/2009	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		SCALE 1:2	
B/O INFORMATION OR SPECIFICATIONS 40mm-6 POINT 3/4 in. DR. (PROTO #J07540M) MODIFIED		PG. SHEET 1 OF 1	
ASSY QTY	Part #	UNIT QTY	Material
		1	STEEL
ASSY QTY	3/O	Description	
		SOCKET	

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing		DEPARTMENT/PROCESS ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality				MRB (QSI042)	
Date : _____		Sequence #: _____		QTY Affected : _____		Disposition			
Description Work Order Deviation									
Root Cause ☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		Completed By Lead hand / Supervisor QC / QA Coordinator							



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB045078**



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045078

PO Date: 11/12/19

Due Date: 11/20/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

2019-11-13

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	200224	RB6798089-3	6798089 Rev A	Spacer Outside Processing - Black Oxide Issue P/O -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed X6	-	11/20/19	6 pcs	0 pcs	6 pcs	\$2.25/pcs	\$13.50
2	201319	RBST2812-P-1	RBST2800-P Rev 1	Base Outsource12 (Outside Processing - Black Oxide) Issue P/O -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; O1 -Certificate of Conformity is required	Firmed X6	-	11/20/19	6 pcs	0 pcs	6 pcs	\$2.95/pcs	\$17.70

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Hawkesbury, ON
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PURCHASE ORDER

POHB045078



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	201018	RBE117-15004W6-1	RBE117-15004W6 Rev B	Drift -Issue P/O -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; O1 -Certificate of Conformity is required	Firmed X7	-	11/20/19	7 pcs	0 pcs	7 pcs	\$9.50/pcs	\$66.50
											NOV 19 2019	
4	197352	RBE350A93-3300-20	RBE350A93-3300-20 Rev 3	Tail Rotor Hub Socket -Issue P/O -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed X14	-	11/20/19	14 pcs	0 pcs	14 pcs	\$6.75/pcs	\$94.50
											NOV 19 2019	
5	200567	RB6795969-5	RB6795969 Rev C	Handle -Issue P/O -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed X7	-	11/20/19	7 pcs	0 pcs	7 pcs	\$4.15/pcs	\$29.05
											NOV 19 2019	
Grand Total:												\$221.25

Sherrin



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
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PURCHASE ORDER

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Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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Certificat de Conformité / Certificate of Compliance

(024053-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

024053 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
18-Nov-2019		Jigar Patel		POHB045078				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Quantités / Quantities				À venir / Back Order
	Job # / Ref #			Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	
1	RB6798089-3 Rev.A	6798089 O1 -OXIDE BLACK [OXIDE BLACK] AS PER MIL-C-13924C CLASS - 1	OXIDE-BLACK CH	6	6	0	0	0
2	RBST2812-P-1 Rev.1	RBST2812-P OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	6	6	0	0	0
3	RBE117-15004W6-1 Rev.B	RBE117-15004W6 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	7	7	0	0	0
4	RB350A93-3300-20 Rev.3	RB350A93-3300-20 O1 -OXIDE BLACK [OXIDE BLACK] AS PER MIL-C-13924C CLASS1	OXIDE-BLACK CH	14	14	0	0	0
5	RB6795969-5 Rev.C	RB6795969 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH					

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DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.